

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW		
Job Number	: 32381	Part Number	: D29381 <i>up</i>		
Estimate Number	: 10940	Drawing Number	: D2938 REV C		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 5/16/2007	Type	: MACHINED PARTS		
Prsht Rev.	: NC	Drawing Revision	: C		
First Issue	: N/A	Material	: N/A		
Previous Run	: 30480	Due Date	: 6/6/2007 Qty: - 16 Um: Each		
Written By	:				
Checked & Approved By	:				
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	Batch No: <i>B25349</i> <i>J.L./07/05/22</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program,part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	<i>J.L./J.F. 07/25/24</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>Sr 07/07/07</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>J.F./Es 07/06/07</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:43 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 32381

Part Number: D29381

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/07/09 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine as per QSI 005 4.1

15

07-06-11

16

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

W.W.

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

PACKAGING RESOURCE #1



9.0 PACKAGING 1

*Stock unprinted*

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 445*P07/7/5 UP (12)*

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) 07/07/09

Job Completion

*W 07.11*

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32381
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.116	.117	.118		
B	0.100	0.140		.114	.116	.117	.118		
C	0.100	0.140		.118	.118	.118	.118		
D	0.210	0.230		.224	.222	.221	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.256	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.234	.231	.234	.235		
N	0.100	0.140		.121	.121	.121	.120		
O	0.540	0.560		.550	.551	.550	.549		
P	0.490	0.510		.499	.498	.498	.501		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.250	.250	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.263	1.260	1.261		
Y	1.565	1.585		1.572	1.575	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	/	6	Audited by:	CMF
Date:	07/05/22	/	07/06/22	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

DART AEROSPACE LTD	Work Order:	32381
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119	.118	.119"		
B	0.100	0.140		.118	.119	.118	.119"		
C	0.100	0.140		.119	.119	.119	.125"		
D	0.210	0.230		.222	.220	.220	.225"		
E	1.245	1.255		1.250	1.250	1.250	1.252"		
F	1.245	1.255		1.250	1.250	1.250	1.250"		
G	2.495	2.505		2.500	2.500	2.500	2.502"		
H	0.510	0.515		.511	.511	.511	.511"		
I	1.572	1.582		1.577	1.577	1.577	1.580"		
J	2.495	2.505		2.500	2.500	2.500	2.500"		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.237		
N	0.100	0.140		.123	.122	.122	.123		
O	0.540	0.560		.550	.549	.551	.551"		
P	0.490	0.510		.502	.498	.498	.502"		
Q	3.715	3.725		3.719	3.719	3.719	3.721"		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.250	.251	.250	.254"		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.631"		
V	1.362	1.372		1.367	1.367	1.367	1.370"		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.265	1.263	1.263	1.263		
Y	1.565	1.585		1.577	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL / JF / En	Audited by:	SM
Date:	07/05/23 / 07/06/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SM

DART AEROSPACE LTD	Work Order:	32381
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119"	.119"	.117"	.118"		
B	0.100	0.140		.120"	.122"	.121"	.121"		
C	0.100	0.140		.126"	.127"	.125"	.126"		
D	0.210	0.230		.224"	.225"	.225"	.225"		
E	1.245	1.255		1.250	1.250	1.252	1.251		
F	1.245	1.255		1.250"	1.250"	1.251"	1.251"		
G	2.495	2.505		2.501"	2.501"	2.503"	2.502"		
H	0.510	0.515		.511"	.511"	.511"	.511"		
I	1.572	1.582		1.581"	1.581"	1.581"	1.580"		
J	2.495	2.505		2.501"	2.502"	2.503"	2.501"		
K	0.257	0.262		.258"	.258"	.258"	.258"		
L	0.312	0.317		.313"	.313"	.313"	.313"		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.123"	.123"	.123"	.123"		
O	0.540	0.560		.550"	.551"	.552"	.550"		
P	0.490	0.510		.504"	.504"	.504"	.505"		
Q	3.715	3.725		3.718"	3.722"	3.722"	3.724"		
R	2.720	2.760		2.740"	2.740"	2.740"	2.740"		
S	0.240	0.270		.253"	.258"	.254"	.254"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.632"	1.632"	1.633"	1.632"		
V	1.362	1.372		1.370"	1.371"	1.369"	1.369"		
W	0.316	0.321		.319"	.319"	.319"	.319"		
X	1.250	1.270		1.262	1.259"	1.266"	1.261"		
Y	1.565	1.585		1.576	1.572"	1.575"	1.575"		
Z	0.178	0.198		A.188"	A.188"	A.188"	A.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	J.F.	Audited by:	J.R.
Date:	07/05/09 / 07/06/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

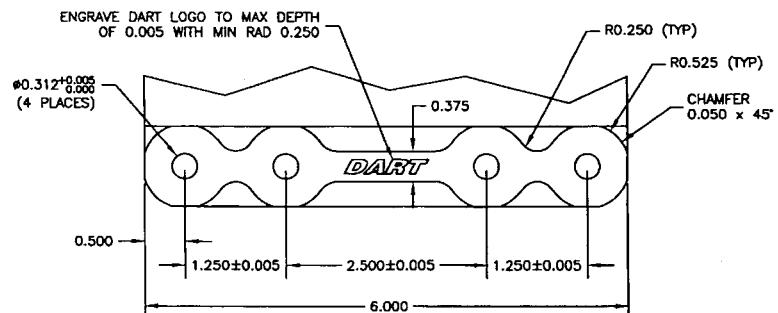
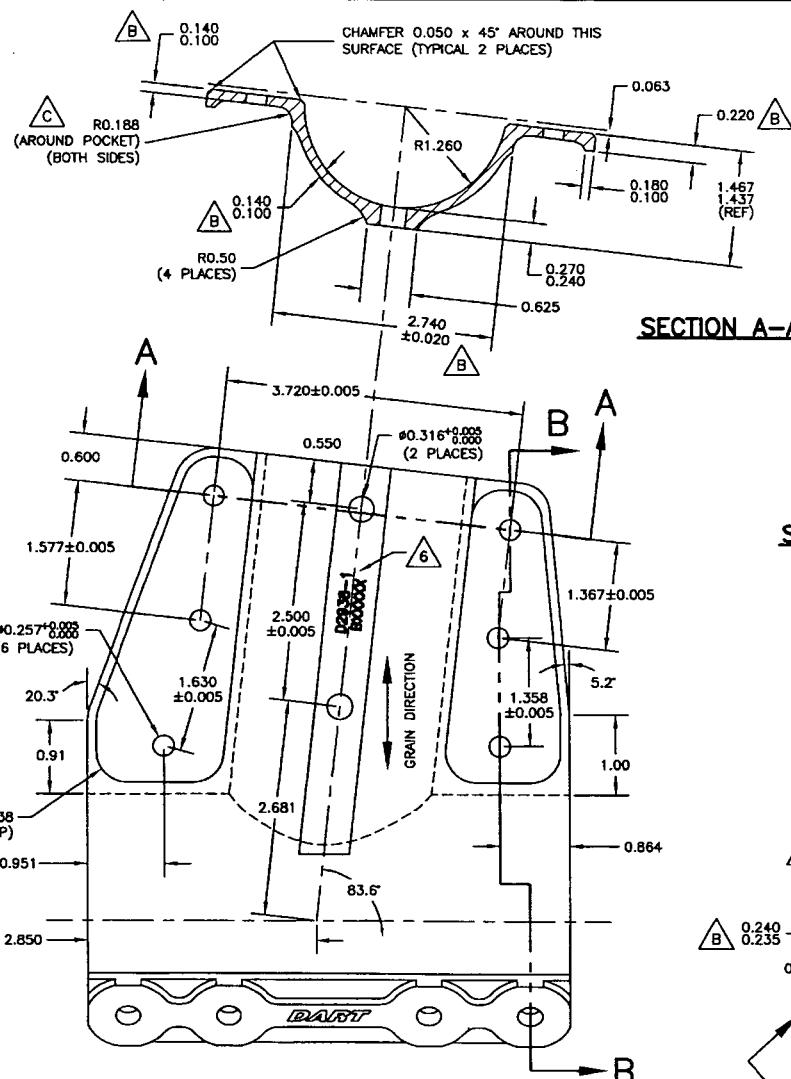
DART AEROSPACE LTD				Work Order:	32381
Description: 206 Saddle, Outboard, Left side				Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

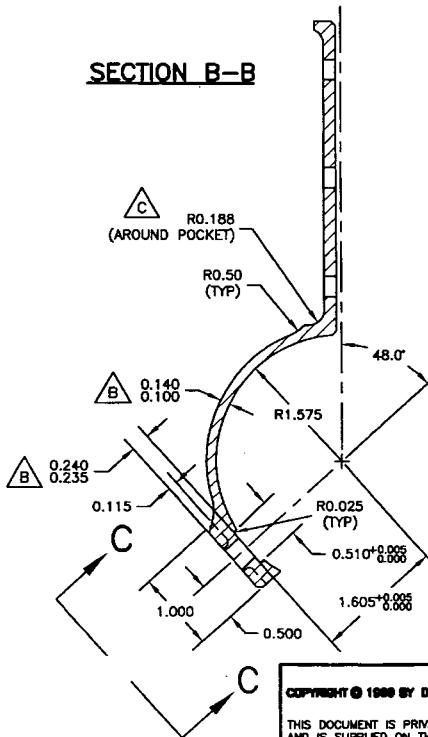
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120"	.118"	.119"	.119"		
B	0.100	0.140		.120"	.120"	.122"	.122"		
C	0.100	0.140		.120"	.126"	.126"	.126"		
D	0.210	0.230		.224"	.226"	.226"	.226"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.251"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.502"	2.501"	2.501"	2.501"		
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"		
I	1.572	1.582		1.582"	1.580"	1.580"	1.580"		
J	2.495	2.505		2.503"	2.501"	2.501"	2.501"		
K	0.257	0.262		.258"	.258"	.258"	.258"		
L	0.312	0.317		.313"	.313"	.313"	.313"		
M	0.235	0.240		.235"	.235"	.235"	.235"		
N	0.100	0.140		.124"	.123"	.123"	.123"		
O	0.540	0.560		.550"	.551"	.550"	.549"		
P	0.490	0.510		.502"	.504"	.502"	.502"		
Q	3.715	3.725		3.721"	3.722"	3.722"	3.722"		
R	2.720	2.760		2.740"	2.740"	2.740"	2.740"		
S	0.240	0.270		.254"	.255"	.255"	.255"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.633"	1.633"	1.633"	1.633"		
V	1.362	1.372		1.370"	1.369"	1.369"	1.369"		
W	0.316	0.321		.319"	.319"	.319"	.319"		
X	1.250	1.270		1.262"	1.262"	1.261"	1.261"		
Y	1.565	1.585		1.575"	1.576"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.	/80	Audited by:	DK
Date:	07/05/09	/07/06/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JL



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM 06101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. RELINE, WA
CHECKED	APPROVED	DRAWING NO. REV. C D2938 SHEET 1 OF 1
DATE	TITLE	SCALE 06.11.09 SADDLE OUTSIDE 2:3

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